












Date: Monday, 11/05/2009 8:47:12 AM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STRUT
Job Number	: 47830		
Estimate Number	: 10285		
P.O. Number	:	Part Number	: D2565111
This Issue	: 11/05/2009	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D2565 REV E
First Issue	: / /	Project Number	: N/A
Previous Run	: 47549	Drawing Revision	: E
Written By	:	Material	:
Checked & Approved By	: <u>JUD09.05.11</u>	Due Date	: 18/05/2009
Comment	Est: E 01.06.04 Added Powder Coat, Removed Polish, and Added Inspection Levels 3 & 21 EC Est: E 06.05.03 Change level 2/8 to QC5 EC		
Additional Product			
Job Number: 			
Seq. #:	Machine Or Operation:	Description :	
1.0	M304TR0750W049	304 RD Tube .750 x .049W	
			
Comment: Qty.: 1.1944 f(s)/Unit Total: 11.9438 f(s) Material: 304/316 SS tubing 0.750" Dia. x 0.049" wall (M304TR0750W049) Batch No: <u>M111457</u> SB 09/05/11 (10)			
2.0	BRAKE NC	NC BRAKE	
			
Comment: BRAKE NC Punch as per Dwg D2565 using DT 8313 SB 09/05/11 (10)			
3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
			
Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr and polish M-1 09/05/11 (10X)			
4.0	QC5	INSPECT WORK TO CURRENT STEP	
			
Comment: INSPECT WORK TO CURRENT STEP S 09/05/11 (x10)			
5.0	POWDER COATING	POWDER COATING	
			
Comment: POWDER COATING Powder Coat White (Ref: 4.3.5.2) as per QSI 005 4.3 (10)			
START TIME: <u>8:25</u> OVEN TEMPERATURE: <u>400°</u> FINISH TIME: <u>8:55</u> FL 09/05/12			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: STRUT

Job Number: 47830

Part Number: D2565111

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



⑩

Comment: INSPECT POWDER COAT

BR 09-05-12

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

ST270

SS 09/05/12 (X)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



09/05/12

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-05-12

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

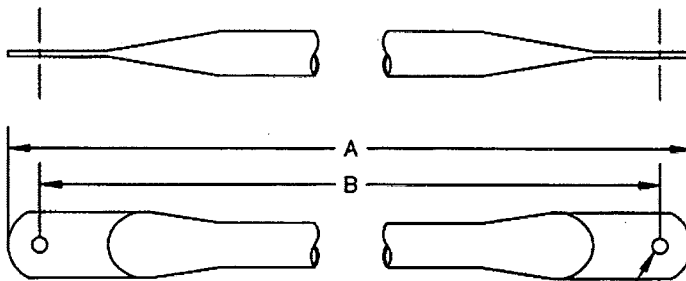
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DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2565	REV. E SHEET 1 OF 1
DATE 04.05.05		TITLE STRUT SCALE 1:3	
A	96.05.03	NEW ISSUE	
B	97.03.15	CORRECT D2565-111 DIM. A	
C	98.10.05	UPDATED MATERIAL NOTE (TSR A603)	
D	02.06.05	ADD -3XX PARTS; ADD FINISH	
E	04.05.05	ADD D2565-401-411; RMV ANGLE D	

RELEASED
04.05.05



DIA 0.257 TO BE PUNCHED
"C" DIA TO BE OPENED MANUALLY

PUNCH ENDS PER SPEC CONTROL DRAWING D2638

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 47830

PART #	A	B	DIA C
D2565-101	20.52	19.72	0.316
D2565-103	18.21	17.41	0.316
D2565-105	20.19	19.39	0.316
D2565-107	13.43	12.63	-
D2565-109	12.31	11.51	-
D2565-111	13.65	12.85	-
D2565-201	22.79	22.00	0.316
D2565-203	20.75	19.95	0.316
D2565-205	21.22	20.42	0.316
D2565-207	16.07	15.27	-
D2565-209	15.16	14.36	-
D2565-211	14.14	13.34	-
D2565-301	27.03	26.23	0.316
D2565-303	25.34	24.54	0.316
D2565-305	23.73	22.93	0.316
D2565-307	20.86	20.06	-
D2565-309	20.17	19.37	-
D2565-311	16.30	15.50	-
D2565-401	18.29	17.49	0.316
D2565-403	15.64	14.84	0.316
D2565-405	19.45	18.65	0.316
D2565-407	10.79	9.99	-
D2565-409	9.34	8.54	-
D2565-411	13.81	13.01	-

GENERAL NOTES

- 1) MATERIAL: AISI 304/316/318 SS 0.750 OD X 0.049 WALL
(REF DART SPEC. M304TR0.750W0.049)
ENSURE SEAMLESS TUBE IS USED
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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Dart Aerospace Ltd

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